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Canada

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**RB T101530-17**  
**Job Sheet R194458**



**Part No:** RB T101530-17

**Job Qty:** 1 pcs

**Part Name:** Bearing Roll Stake Bolt



**Part Weight:** 0 lbs

**Status:** New

**Priority:** Medium

**Job Created:** 5/2/19

**Job Tracking No:**

**Due Date:** 5/30/19

**Created By:** Jennifer Renwick

**Type:** Rework

**Description:**

**Note:** DWG RB T101530 Rev.A IPP Rev. A 18.05.30 new issue DP Verify DD/IPP Rev. B 18.07.04 new DWG. DP Verify DD

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation                     | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier    |           | Sign-off |
|-------|-------------------------------|-------|------------|----------|-----------|---------|------------------------|-----------|----------|
|       |                               |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier  | Lead Time |          |
| 300   | Rework Startup                | 1 pcs | 5/30/19    | 5/30/19  | 0.00      | 0.00    |                        |           |          |
| 310   | Outsource - 1 - Heat Treat    | 1 pcs | 5/30/19    | 5/30/19  | 0.00      | 0.00    |                        |           |          |
| 320   | Packaging 2-1 - Receive - B4B | 1 pcs | 5/30/19    | 5/30/19  | 0.00      | 0.00    | Packaging 2 - 1 - B4B  |           |          |
|       |                               |       |            |          |           |         | Packaging 2 - 2 - B4B  |           |          |
|       |                               |       |            |          |           |         | Packaging 2 - 3 - B4B  |           |          |
|       |                               |       |            |          |           |         | Packaging 2 - 5 - B4B  |           |          |
|       |                               |       |            |          |           |         | Packaging 2 - 4 - B4B  |           |          |
|       |                               |       |            |          |           |         | Packaging 2 - 6 - B4B  |           |          |
|       |                               |       |            |          |           |         | Packaging 2 - 7 - B4B  |           |          |
|       |                               |       |            |          |           |         | Packaging 2 - 8 - B4B  |           |          |
|       |                               |       |            |          |           |         | Packaging 2 - 9 - B4B  |           |          |
|       |                               |       |            |          |           |         | Packaging 2 - 10 - B4B |           |          |
|       |                               |       |            |          |           |         | Packaging 2 - 11 - B4B |           |          |
|       |                               |       |            |          |           |         | Packaging 2 - 12 - B4B |           |          |
|       |                               |       |            |          |           |         | Packaging 2 - 13 - B4B |           |          |
|       |                               |       |            |          |           |         | Packaging 2 - 14 - B4B |           |          |
|       |                               |       |            |          |           |         | Packaging 2 - 15 - B4B |           |          |
|       |                               |       |            |          |           |         | Packaging 2 - 16 - B4B |           |          |
|       |                               |       |            |          |           |         | Packaging 2 - 17 - B4B |           |          |
|       |                               |       |            |          |           |         | Packaging 2 - 18 - B4B |           |          |
|       |                               |       |            |          |           |         | Packaging 2 - 19 - B4B |           |          |
|       |                               |       |            |          |           |         | Packaging 2 - 20 - B4B |           |          |
|       |                               |       |            |          |           |         | Packaging 2 - 21 - B4B |           |          |
|       |                               |       |            |          |           |         | Packaging 2 - 22 - B4B |           |          |
|       |                               |       |            |          |           |         | Packaging 2 - 23 - B4B |           |          |
|       |                               |       |            |          |           |         | Packaging 2 - 24 - B4B |           |          |
|       |                               |       |            |          |           |         | Packaging 2 - 25 - B4B |           |          |
|       |                               |       |            |          |           |         | Packaging 2 - 26 - B4B |           |          |
|       |                               |       |            |          |           |         | Packaging 2 - 27 - B4B |           |          |
|       |                               |       |            |          |           |         | Packaging 2 - 28 - B4B |           |          |
|       |                               |       |            |          |           |         | Packaging 2 - 29 - B4B |           |          |
|       |                               |       |            |          |           |         | Packaging 2 - 30 - B4B |           |          |
|       |                               |       |            |          |           |         | Packaging 2 - 31 - B4B |           |          |
|       |                               |       |            |          |           |         | Packaging 2 - 32 - B4B |           |          |
|       |                               |       |            |          |           |         | Packaging 2 - 33 - B4B |           |          |
|       |                               |       |            |          |           |         | Packaging 2 - 34 - B4B |           |          |
|       |                               |       |            |          |           |         | Packaging 2 - 35 - B4B |           |          |
|       |                               |       |            |          |           |         | Packaging 2 - 36 - B4B |           |          |
| 330   | QC 6                          | 1 pcs | 5/30/19    | 5/30/19  | 0.00      | 0.00    | QC 6 - 9               |           |          |
|       |                               |       |            |          |           |         | QC 6 - 68              |           |          |
|       |                               |       |            |          |           |         | QC 6 - 61              |           |          |

Plex 5/2/19 2:10 PM Dart.Renwick.Jennife

|                                                                                                                                                                                                                                                                                                             |                               |                 |                    | QC 6 - 40              |      |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------|-----------------|--------------------|------------------------|------|
| 340                                                                                                                                                                                                                                                                                                         | Outsource - 12 - Black Oxide  | 1 pcs           | 5/30/19            | 0.00                   | 0.00 |
| 350                                                                                                                                                                                                                                                                                                         | Packaging 2-2 - Receive - B4B | 1 pcs           | 5/30/19            | 0.00                   | 0.00 |
|                                                                                                                                                                                                                                                                                                             |                               |                 |                    | Packaging 2 - 1 - B4B  |      |
|                                                                                                                                                                                                                                                                                                             |                               |                 |                    | Packaging 2 - 2 - B4B  |      |
|                                                                                                                                                                                                                                                                                                             |                               |                 |                    | Packaging 2 - 3 - B4B  |      |
|                                                                                                                                                                                                                                                                                                             |                               |                 |                    | Packaging 2 - 5 - B4B  |      |
|                                                                                                                                                                                                                                                                                                             |                               |                 |                    | Packaging 2 - 4 - B4B  |      |
|                                                                                                                                                                                                                                                                                                             |                               |                 |                    | Packaging 2 - 6 - B4B  |      |
|                                                                                                                                                                                                                                                                                                             |                               |                 |                    | Packaging 2 - 7 - B4B  |      |
|                                                                                                                                                                                                                                                                                                             |                               |                 |                    | Packaging 2 - 8 - B4B  |      |
|                                                                                                                                                                                                                                                                                                             |                               |                 |                    | Packaging 2 - 9 - B4B  |      |
|                                                                                                                                                                                                                                                                                                             |                               |                 |                    | Packaging 2 - 10 - B4B |      |
|                                                                                                                                                                                                                                                                                                             |                               |                 |                    | Packaging 2 - 11 - B4B |      |
|                                                                                                                                                                                                                                                                                                             |                               |                 |                    | Packaging 2 - 12 - B4B |      |
|                                                                                                                                                                                                                                                                                                             |                               |                 |                    | Packaging 2 - 13 - B4B |      |
|                                                                                                                                                                                                                                                                                                             |                               |                 |                    | Packaging 2 - 14 - B4B |      |
|                                                                                                                                                                                                                                                                                                             |                               |                 |                    | Packaging 2 - 15 - B4B |      |
|                                                                                                                                                                                                                                                                                                             |                               |                 |                    | Packaging 2 - 16 - B4B |      |
|                                                                                                                                                                                                                                                                                                             |                               |                 |                    | Packaging 2 - 17 - B4B |      |
|                                                                                                                                                                                                                                                                                                             |                               |                 |                    | Packaging 2 - 18 - B4B |      |
|                                                                                                                                                                                                                                                                                                             |                               |                 |                    | Packaging 2 - 19 - B4B |      |
|                                                                                                                                                                                                                                                                                                             |                               |                 |                    | Packaging 2 - 20 - B4B |      |
|                                                                                                                                                                                                                                                                                                             |                               |                 |                    | Packaging 2 - 21 - B4B |      |
|                                                                                                                                                                                                                                                                                                             |                               |                 |                    | Packaging 2 - 22 - B4B |      |
|                                                                                                                                                                                                                                                                                                             |                               |                 |                    | Packaging 2 - 23 - B4B |      |
|                                                                                                                                                                                                                                                                                                             |                               |                 |                    | Packaging 2 - 24 - B4B |      |
|                                                                                                                                                                                                                                                                                                             |                               |                 |                    | Packaging 2 - 25 - B4B |      |
|                                                                                                                                                                                                                                                                                                             |                               |                 |                    | Packaging 2 - 26 - B4B |      |
|                                                                                                                                                                                                                                                                                                             |                               |                 |                    | Packaging 2 - 27 - B4B |      |
|                                                                                                                                                                                                                                                                                                             |                               |                 |                    | Packaging 2 - 28 - B4B |      |
|                                                                                                                                                                                                                                                                                                             |                               |                 |                    | Packaging 2 - 29 - B4B |      |
|                                                                                                                                                                                                                                                                                                             |                               |                 |                    | Packaging 2 - 30 - B4B |      |
|                                                                                                                                                                                                                                                                                                             |                               |                 |                    | Packaging 2 - 31 - B4B |      |
|                                                                                                                                                                                                                                                                                                             |                               |                 |                    | Packaging 2 - 32 - B4B |      |
|                                                                                                                                                                                                                                                                                                             |                               |                 |                    | Packaging 2 - 33 - B4B |      |
|                                                                                                                                                                                                                                                                                                             |                               |                 |                    | Packaging 2 - 34 - B4B |      |
|                                                                                                                                                                                                                                                                                                             |                               |                 |                    | Packaging 2 - 35 - B4B |      |
|                                                                                                                                                                                                                                                                                                             |                               |                 |                    | Packaging 2 - 36 - B4B |      |
| 360                                                                                                                                                                                                                                                                                                         | QC 6                          | 1 pcs           | 5/30/19            | 0.00                   | 0.00 |
|                                                                                                                                                                                                                                                                                                             |                               |                 |                    | QC 6 - 9               |      |
|                                                                                                                                                                                                                                                                                                             |                               |                 |                    | QC 6 - 68              |      |
|                                                                                                                                                                                                                                                                                                             |                               |                 |                    | QC 6 - 61              |      |
|                                                                                                                                                                                                                                                                                                             |                               |                 |                    | QC 6 - 40              |      |
| Part Op 310 - 1--Issue P/O _____ RC 28-32 2-Bead blast 3- Certificate of Conformity is required<br>Descriptions: 330 - ***PLEASE VERIFY DIMENSIONS TO THE DWG BEFORE SENDING IT TO BLACK OXIDE***<br>340 - -Issue PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required |                               |                 |                    |                        |      |
| <b>Job BOM</b>                                                                                                                                                                                                                                                                                              |                               |                 |                    |                        |      |
| <b>Part / Item</b>                                                                                                                                                                                                                                                                                          | <b>Component Name</b>         | <b>Quantity</b> | <b>Operation</b>   | <b>Container</b>       |      |
| RB T101530-17P                                                                                                                                                                                                                                                                                              | Bearing Roll Stake Bolt       | 1 Ea (1 ea)     | 300-Rework Startup |                        |      |
| <b>Job Allocations</b>                                                                                                                                                                                                                                                                                      |                               |                 |                    |                        |      |
| <b>Operation</b>                                                                                                                                                                                                                                                                                            | <b>Component Part</b>         | <b>Required</b> | <b>Inventory</b>   | <b>Allocated</b>       |      |
| 300-Rework Startup                                                                                                                                                                                                                                                                                          | RB T101530-17P                | 1               | 0                  | 0                      |      |
| <b>Part Specifications</b>                                                                                                                                                                                                                                                                                  |                               |                 |                    |                        |      |
| Specifications could not be found.                                                                                                                                                                                                                                                                          |                               |                 |                    |                        |      |

Plex 5/2/19 2:10 PM Dart.Renwick.Jennifer

Job  
R.194458

S7 - 9

# NOTES:

1) MATERIAL: 4140/4142 (28-32 RC) OR 17-4 PH-H900-H1150 STAINLESS STEEL

2) HEAT TREAT: N/A

3) FINISH: 17-4PH: N/A

4140/4142: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°

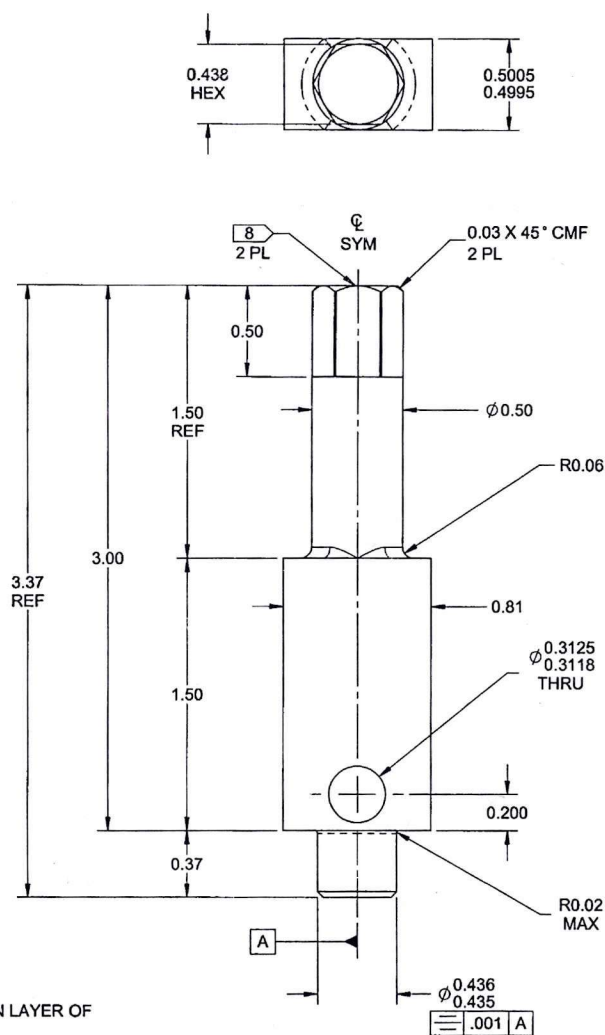
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: 0.005" TO 0.010"

7) IDENTIFICATION: MACHINE ENGRAVE PER CAD MODEL OR DOT MARK T/N AS SHOWN.

8) CENTER DRILL IS ACCEPTABLE



RB T101530-17 BODY

|                                                                                                                                                                                                                                |               |                             |               |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------|-----------------------------|---------------|
| DESIGN                                                                                                                                                                                                                         | KK            | <b>DART AEROSPACE LTD</b>   |               |
| DRAWN                                                                                                                                                                                                                          | KK            | HAWKESBURY, ONTARIO, CANADA |               |
| CHECKED                                                                                                                                                                                                                        | <i>M. Lee</i> | TOOL PART #                 | REV. A        |
| MFG. APPR.                                                                                                                                                                                                                     | DP            | RB T101530                  | SHEET 9 OF 10 |
| APPROVED                                                                                                                                                                                                                       | <i>M. Lee</i> | TITLE                       | SCALE         |
| DATE 7/4/2018                                                                                                                                                                                                                  |               | BEARING ROLLER TOOL (-3/-5) | NTS           |
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